

SPLIT

Date: Monday, 04/05/2009 1:47:05 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 47715 -2	
Estimate Number : 12712	
P.O. Number :	Part Number : D35371 64
This Issue : 04/05/2009 S.O. No. :	Drawing Number : D3537 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 47530	Material :
Written By :	Due Date : 20/05/2009 Qty: 60 Um: Each
Checked & Approved By : <u>JLD 09-05-06</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
Comment: Qty.: 0.1113 sf(s)/Unit Total : 6.6780 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>111323</u> <u>IB 9-5-21</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> <u>IB 9-5-21</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>IB 9-5-21</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 9-5-21</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>S 27/05/21</u> <u>counter</u> <u>(X74)</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1 <u>SB 29/05/21</u> <u>(74)</u>		

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 47715

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
A/R 2059B Hardcoat

Batch

7111585

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

PR 9-5-26 (x74)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

801526 (x54)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

801526 (x54) center

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

3:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:30pm

96 09-05-26 (x67)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR LMO 09/05/27 (x67)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-17

LMO 09/05/27 (x67)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

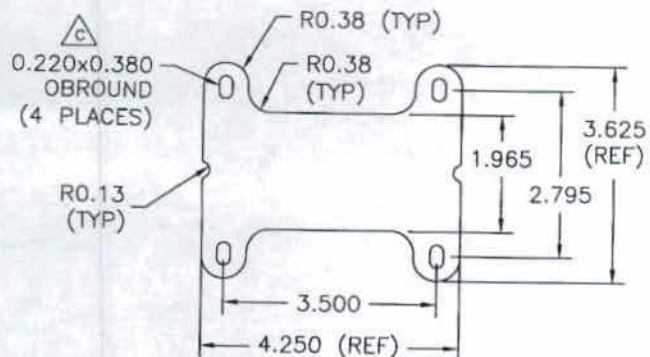
09/05/28

Job Completion

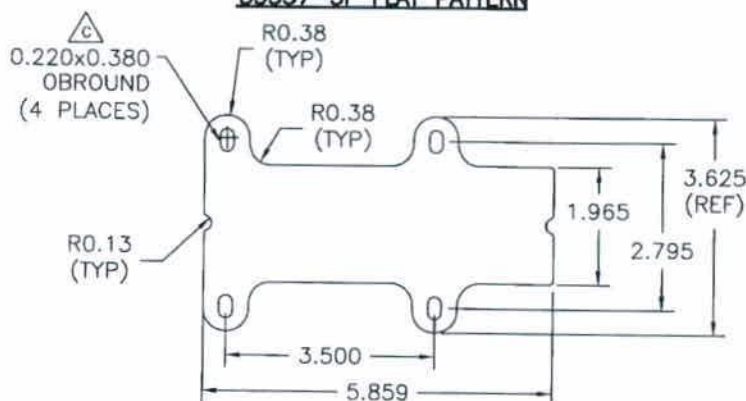


MF 09-05-28

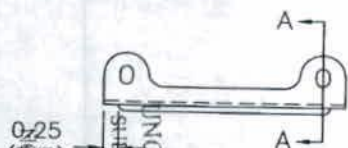
D3537-1F FLAT PATTERN



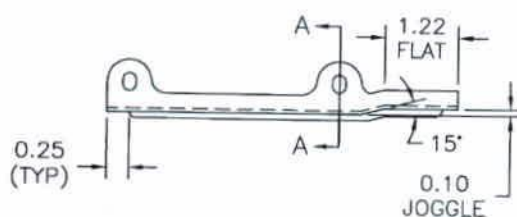
D3537-3F FLAT PATTERN



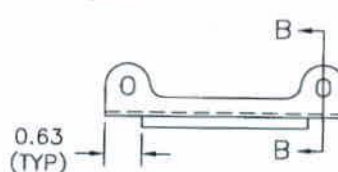
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



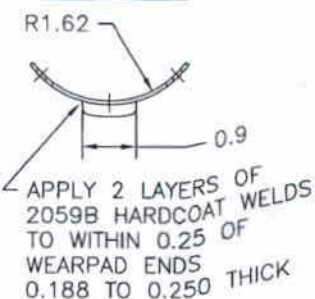
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



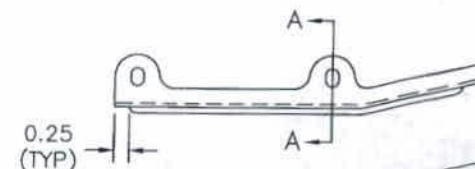
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

WLO
47715

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

SHEET 1